

Work Order ID 51826

September 4, 2009 9:04:59 AM



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Item ID: D3882-1-130
Revision ID: A
Item Name: Extrusion "I" Beam

Accept



Setup Start



Stop



Start Date: 9/04/09 Start Qty: ~~40.00~~ 63

Required Date: 9/18/09 Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: CL

Date: 09/09/04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3882	Rev A
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100

0.00



Purchasing

Memo

0.00

PURCHASING

Issue P/O: 10350

a) Extrude as per Dwg D3882

b) Material: 6061-T6 (QQ-A-200/8) OR ASTM B221

c) Minimum yield tensile strength = 35 ksi

d) Minimum ultimate tensile strength = 38 ksi

e) Minimum elongation = 8%

f) Order at 130" long

g) Bon L. Canada Inc. tool #DAA-6

H Pull test to ASTM standard B221 required.

J) Material certification is required

CL 09/09/04

63

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

CL 9/9/23

63

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51826

September 4, 2009 9:04:59 AM

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Item ID: D3882-1-130

Accept

Revision ID: A

Item Name: Extrusion "I" Beam

Start Date: 9/04/09 Start Qty: 40.00

Required Date: 9/18/09 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

27 8/07/09/23

Location
(63)

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: Hall002 0.00

0.00

SAP 09-09-24
CP 09-09-24

(63)

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

0.00

QC

Memo

Quality Control

09/09/24
MC 09-09-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51826

Parent Item: D3882-1-130RevA

Parent Item Name: Extrusion "I" Beam



Comments:

Start Date: 9/04/09

Required Date: 9/18/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3882-1-130P		Manufactured	No				Each	0.0000	40.0000			
										<div>14/9/23 (63)</div>		
EXTRUSION												

9/9/23 (63)

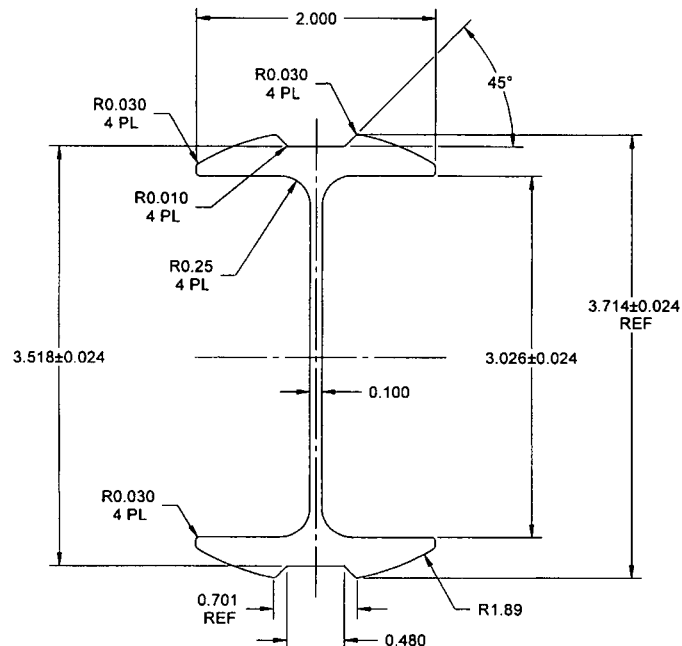
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



GENERAL NOTES:

1) MATERIAL: 6061-T6 PER QQ-A-200/8 OR ASTM B221
 MINIMUM TENSILE YIELD STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
 MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO
 ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY
 TO ENSURE THAT THE BATCH MEETS THE ABOVE
 MINIMUM MECHANICAL PROPERTIES

2) BREAK ALL SHARP CORNERS 0.010 MAX

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

5) PART NUMBER IS D3882-1-XXX WHERE XXX IS
 CUT LENGTH IN INCHES (EX. D3882-1-180 IS 180" LONG)

6) D3882-1 EXTRUSION MANUFACTURED FROM: DIE # DAA-6

D3882-1 EXTRUSION

RELEASED
 06/15/14

C209109104
 W10' S1826

A NEW ISSUE		RF	09.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3882	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		EXTRUSION	NTS
DATE	09.01.23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
500 EDWARD AVENUE
RICHMOND HIL ON L4C 4Y9

SHIPPING MANIFEST

ACCT# 00046024

MANIFEST DATE	09-22-09
MANIFEST NUMBER	668364
SALES ORDER NUMBER	54739

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

TERMS / FREIGHT
O / P

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200
--	--

CREDIT REP HAMBROOK, PAU 905-508-3250	SALES REP
FIELD SALES REP Kutter A 450-435-6551	CUST SERVICE REP Burton D 905-427-2227

CUSTOMER ID 46024	ORDER DATE 09/04/09	CUSTOMER PO NUMBER 10350	JOB	BILL OF LADING NUMBER 08399180
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ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT			UNIT	QUANTITY DUE
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION	NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
					CUTTING TOLERANCE	SHIPPING TOLERANCE					
01	63	KG	0	DAA-6-1	6061 /T6	MILL	1	520	510	KG	0
		M	0	D3882-1	130"	CERTIFICATE OF COMP			208.03	M	0
		PC	0		+3/16 "	(+015-015,0072-0053)			63	PC	0
				LOT/TKT DETAIL:		54739010 / 219614	1	520	510		63 PC
09/24/23											

09/24/23

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accord. ce with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

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1	520	510	KG
		208.03	M
		63	PC
TOTALS			

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cert Date	Cert No	Sales Order	Page
09/22/09	197966	54739	1
Cust PO	B/L No	Lot	Date
10350	08399180	54739010	9/22/09

Sold To	Ship To
46024	46024
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-6-1	130" MILL 6061 T6	D3882-1

Gross Weight	520 KGS
Net Qty	510 KG 63 PC 208 M 1 PKG

Specification	Die Desc
ASTM B221-08	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	322.1 / 46.7	298.0 / 43.2	13.0	.0	94

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.76	.49	.34	.11	.90	.06	.007	.16	.000	.010	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Handwritten signature
09/25/09

D. VanBakel, QA Manager Signature Aluminum Canada Inc



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10350

Purchase Order Date 9/04/09

PO Print Date 9/04/09

Page Number 1 of 1

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

FAXED
9/4/09

Contact Name

Vendor Phone

800 563 1079

Vendor Fax

800 565 8339

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3882-1-130P	EXTRUSION	9/25/09 Yes	✓ 63.00 Each		\$43.8780	\$2,764.3

Special Inst:

EXTRUDE AS PER DWG D3882 REV. A
MATERIAL: 6061-T6 (QQ-A-200/8)
OR ASTM B221
MINIMUM YIELD TENSILE STRENGTH
= 35KSI
MINIMUM ULTIMATE TENSILE
STRENGTH = 38KSI
MINIMUM ELONGATION = 8%
130" LONG
BON L CANADA INC. TOOL #DAA-6
PULL TEST TO ASTM STANDARD B221
REQUIRED
B51826

PO Total:

\$2,764.3

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

Change Nbr:

1

Change Date: 9/04/09

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required when applicable